

# Work Order ID 53639-2

November 11, 2009 11:42:17 AM



SPLIT-2

Page 1

Item ID: D3511-041  
 Revision ID: A  
 Item Name: Wearplate Assembly  
 Start Date: 11/11/2009 Start Qty: 8.00  
 Required Date: 11/20/2009 Req'd Qty: 8.00

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:



Reference:

Approvals:

Process Plan: MF

Date: 07-11-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3511

Rev A

0.00

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3511 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
 Deburr if necessary ☐ Identify as D3511-1

IB 9-11-17

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

IB 9-11-17

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

2) S 02/11/18

(416) f

16



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Page 2

Item ID: D3511-041  
Revision ID: A  
Item Name: Wearplate Assembly  
Start Date: 11/11/2009 Start Qty: 8.00  
Required Date: 11/20/2009 Req'd Qty: 8.00  
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

Small Fab

Memo

Bend fwd 90 deg. per dwg D3511

0.00

0.00

809/4/18

16

8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

809/6/18

716

f

150



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: ~~11108775~~ 0.00  
Large Fab ~~11108775~~

Memo

weld cups as per dwg

0.00

809.11.30

11X

10X





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Page 3

Item ID: D3511-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearplate Assembly

Start Date: 11/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 11/20/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Small Fab

Small Fab

Small Fab

Memo

Form as per Dwg D3511

0.00

0.00

80 09/12/01

11

18

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

60 09/11/30 60 09/12/01

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 8 01/12/01

4/11



Work Order ID 53639  
November 11, 2009 11:42:17 AM



Item ID:  
Revision ID:  
Item Name:  
Start Date:  
Required Date:  
Reference:

D3511-041  
A  
Wearplate Assembly  
11/11/2009 Start Qty: 8.00  
11/20/2009 Req'd Qty: 8.00



Accept



Setup Start  
Stop



Cust Item ID:  
Customer:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop



Sequence ID/  
Work Center ID

190



Powdercoat  
Powder Coating

Operation  
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

START TIME:

8:50

OVEN TEMPERATURE:

320° FINISH TIME:

9:20

0.00

1209-12-2

(11)

QC3- Inspect Part Finish

0.00

14 09/12/02

(X11)

Ø

Memo

0.00

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

9/12/2 (71-51)

Memo

0.00

200



QC  
Quality Control

210



Packaging  
Packaging





**Work Order ID 53639**  
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**Item ID:**  
**Revision ID:**  
**Item Name:**  
**Start Date:**  
**Required Date:**  
**Reference:**

D3511-041  
A  
Wearplate Assembly  
11/11/2009 Start Qty: 8.00  
11/20/2009 Req'd Qty: 8.00



Accept



Setup Start



Stop



Cust Item ID:

Customer:

**Approvals:**

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



**Sequence ID/**  
**Work Center ID**

220



QC

Quality Control

**Operation**  
**Description**

QC21- Final Inspection - Work Order Release

**Set Up/**  
**Run Hours**

0.00

**Draw**  
**Number**

**Draw**  
**Rev.**

**Plan**  
**Code**

**Accept**  
**Qty**

**Reject**  
**Qty**

**Reject**  
**Number**

**Insp.**  
**Stamp**

Memo

0.00

09/12/03

pl 09-12-3

(11)



# Worklist Print

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Page 1

Work Order ID: 53639

D3511-041RevA

Parent Item:

Name: Wearplate Assembly

Start Date: 11/11/2009

Required Date: 11/20/2009

Comments:

IPP Rev:B New process 06-05-05 EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3503-1RevA		Manufactured	No			150	Each	27.0000	64.0000			

D3503-1RevA

Cup

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

47971

Purchased

No

100

sf

11.5000

12.4968

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

107676

107875

113161

11.5

8.5

3

40X  
87x

IX  
30

HB 9-11-17

16

113161

M304S188

304 SHEET 0.188





DART AEROSPACE LTD		Work Order:	53639
Description: Wearplate		Part Number:	D3511-1
Inspection Dwg: D3511	Rev: A	Page 1 of 1	

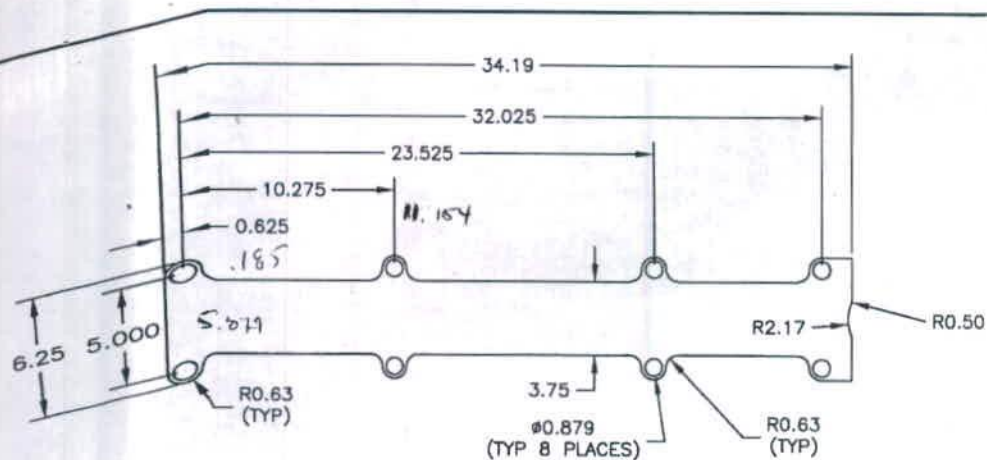
☒ First Article ☐ Prototype

[illegible]

Measured by: <b>IB</b>	Audited by: <b>S</b>	Prototype Approval:	N/A
Date: <b>9-11-17</b>	Date: <b>02/11/18</b>	Date:	N/A

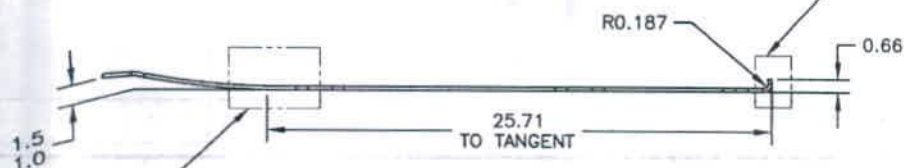
Rev	Date	Change	Revised by	Approved
A	06.05.08	New Issue P/O D3511-041	KJ/JLM	
B	07.01.17	Dimensions updated	KJ/JLM	





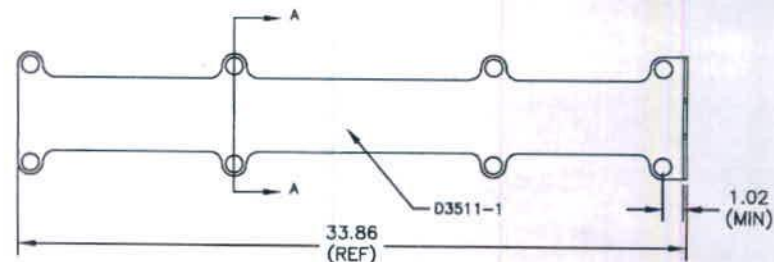
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING



**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**SECTION A-A**

**D3511-041 WELD DETAIL**

**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY-041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CLIP

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A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	JAH	APPROVED
DATE	06.04.04	DRAWING NO. D3511
		TITLE WEARPLATE
		REV. A SHEET 1 OF 1
		SCALE NTS

RELEASED

06 04 25

#53639

